Work Order ID 58339

Monday, May 03, 2010 2:55:04 PM



Page 1

Item ID:

D3909-1

Accept

Setup Start



Revision ID:

Item Name:

Required Date: 5/12/2010

Lug Plate, Fwd Crosstube

Start Date:

5/3/2010

QC:

Start Qty: 24.00

Req'd Qty: 24.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

mp

Date: 10 - 5 - 3 Tooling:

Date: _____

Date: Date:

Start Run

Stop

Stop

Sequence ID/ Work Center ID

Operation Description

Revision Nbr

Set Up/ **Run Hours**

0.00

0.00

SPC (Y/N):

Draw Number

Plan Draw Rev.

Accept Code **Qty**

Reject Qty

Reject Insp. Number Stamp

Draw Nbr

D3909 В

100

FLOW CNC Waterjet

Waterjet

Memo

Cut as per dwg D3909

Prog Rev:_ Dwg Rev:

Deburr as required

my not pulled

B 10-5-4

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

AB10-5-4

	-										
W/O:		WORK ORDER CHANGES									
DATE STEP		PR	OCEDURE CHA	NGE	Ву	Date Qty Appl Chief Prod		Approval QC Inspector			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :	Date: _				
				Disposition: QA: N/C Closed: Date: _							
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)					
DATE	STEP	Description of NC	Corrective Action Section			Verification	Approval	Approval			
	J	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
					:						
		•									
,											
,											
	1										

Work Order ID 58339

Monday, May 03, 2010 2:55:04 PM



Page 2

Item ID:

D3909-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 5/12/2010

Lug Plate, Fwd Crosstube

Start Date:

5/3/2010

Start Oty: 24.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Req'd Qty: 24.00

Date:

Tooling:

SPC (Y/N):

0.00

Date:

Date: ____

Run

Stop

Start

Sequence ID/ Work Center ID

120

Ouality Control

Operation Description

OC8- Inspect parts - second check

QC: Date:

Memo

Memo

Set Up/

Run Hours

Draw Number

Draw Plan Rev. Code Accept

Reject

Reject Insp. Number

Stamp

150

Packaging

Packaging

Identify as per dwg & Stock Location: 95

0.00

0.00

10055

160

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

10 65/06 987 MF10-5-6

0.00

W/O:			WORK ORDER CHANGES									
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								i '				
						- 						
Part No	:	PAR #:	Fault Cate	_ Fault Category: NCR: Yes No DC				DQA: Date:				
	Resolution:		Disposition: QA: N/C Closed:			osed:	sed: Date:					
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)	X ^p .					
DATE	STEP	Description of NC		on B	cation Approval		Approval					
	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector				
		·				* 						
- 1.1 · · · · · · · · · · · · · · · · · ·												
						1						
		<u> </u>										
							į					

Picklist Print

Monday, May 03, 2010 2:55:04 PM

Work Order ID: 58339

Parent Item:

D3909-1

Parent Item Name: Lug Plate, Fwd Crosstube

IPP RevA: new issue DD 09.11.17 verified by:EC Comments: per revPA3 DD verified by:EC

DD 10.04.20 verified by:EC

IPP RevB: as

IPP Rev:C as per dwg revB

Start Date: 5/3/2010

Required Date: 5/12/2010

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/

M304S11GA

Replacement Mfg/

Purchased

Bin No

Primary

Last

MAT19

Route 100

Unit of sf

Qty on 66.8500 Qty per Kit Qty 0.195

4.7

Date

Status

Page 1

304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT	62.38	
114488	62.38	

112663

4.47 4.47

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						1						
							 					
Part No: PAR #:			Fault Cate	gory:	NCF	R: Yes	No DQ	4 :	_ Date: _			
	Res	Resolution: Disposition: O					osed:		Date: _			
NCR:			WORK ORDE	R NON-CONFOR	MANCE	(NCR)	· · · · · · · ·				
DATE	STEP	Description of NC	Corrective Action Section B			Verifi		cation Approva	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Secti		Chief Eng	QC Inspector		
				·					4			
-								,				
									:			

DART AEROSPACE LTD	Work Order:	58339
Description: Lug Plate, Fwd Crosstube	Part Number:	D3909-1
Inspection Dwg: D3909 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

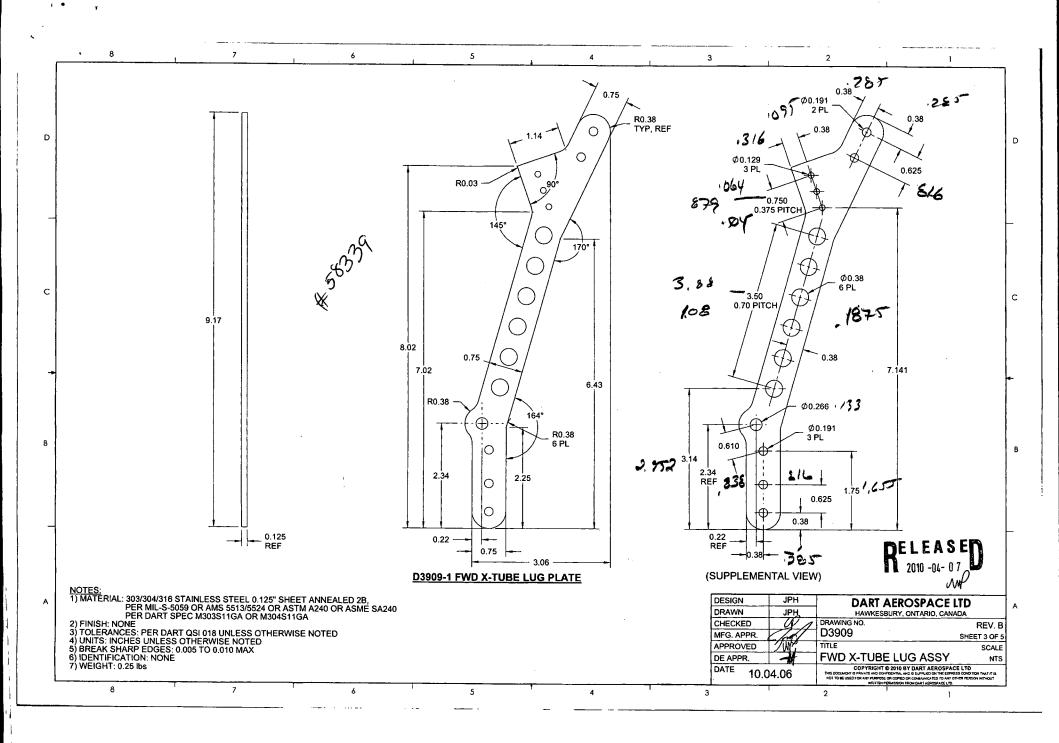
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	131	8			
Ø0.191	+0.005/-0.001	193	X 0	 		
Ø0.266	+0.006/-0.001	266	7			
Ø0.38	+0.006/-0.001	.380				
0.75	+/-0.030	756	*			
1.14	+/-0.030	1.132	*			
0.22	+/-0.030	.211)			
2.34	+/-0.030	2,345	75			
7.02	+/-0.030	7.00	٧			
8.02	+/-0.030	8,011	80			
0.38	+/-0.030	,319	×			
0.625	+/-0.010	.634	X.			
0.750	+/-0.010	1750	S			
0.375	+/-0.010	376	7			
3.50	+/-0.030	3,000	٢			
0.70	+/-0.030	.760	ж			
3.14	+/-0.030	3,140	Y			
0.610	+/-0.010	.610	¥ª.			
0.625	+/-0.010	. 673	* *			
1.75	+/-0.030	1,752	×			
7.141	+/-0.010	7.138	×			
0.125	+/-0.010	130	7			

Measured by:	Audited by:	Preliminary Approval:	<u>a</u> [
Date: 10-5-4	Date: (0/05/05)	Date:	14

Rev	Date	Change	Revised by 🔨	Approved
Α	10.04.20	New Issue	KJ 📢	78
			. 177	

•	٤	4	

W/O:	WORK ORDER CHANGES					;						
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date Q		Approval QC Inspector			
								Prod Mgr	a map action			
Part No: PAR #: Fault Category:			NCI	R: Yes I	No DQA: _	Date: _						
Resolution:		Disposit	Disposition: QA: N/C Closed:					Date:				
NCR:		1	WORK OR	DER NON-CONFO	DRMANCE	(NCR)	, .		- ''			
DATE	STEP	Description of NC			Section B	Verification		n Approval	Approval			
	JILI	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date	Section C	Chief Eng	QC Inspector			
					:				<u> </u>			
-												
		 v							-			
								,				
							 					
	,,,											
									F			
MOTE. D							_L	ı	1			



	•											
W/O:			WC	ORK ORDER CHANG	GES							
DATE STEP		PR	PROCEDURE CHANGE By			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No			Fault Category: NC			NCR: Yes No DQA: Date:						
Resolution:			Dispositio	Disposition: QA: N/C Closed: Date					Date:			
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)					
DATE	STEP	Description of NC		Corrective Action Section B		0: 0	Verific	ation	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector		
					Ì							
						·						
									at .			
			;			- : -						